



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D4884-1

Job Sheet 183453



Part No: D4884-1

Job Qty: 4 ea

Part Name: End Fitting, Eye



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/18/18

Job Tracking No:

Due Date: 10/12/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV A SHEET 1 IPP REV:A NEW ISSUE 14-01-13 JLM VERIFIED BY:DD IPP REV:B DOING PART IN HOUSE FROM NOW ON. RQ 16.11.02 VERIFIED BY: JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea	10/12/18	10/12/18	0.00	0.00	Start Up Machining-3		
105	Doosan	10 pcs	10/12/18	10/12/18	0.00	7.52	Doosan		
110	QC	10 pcs	10/12/18	10/12/18	0.00	0.00	QC2 Machining-3		
115	CNC Vertical Machining	10 pcs	10/12/18	10/12/18	0.21	9.26	HAAS 5 Axis		
117	QC	10 pcs	10/12/18	10/12/18	0.00	0.00	QC2 Machining-3		
120	QC	10 pcs	10/12/18	10/12/18	0.00	0.00	QC8 Machining-3		
130	Outsource	10 pcs	10/12/18	10/12/18			SKY002-VC	6	
140	Packaging	10 pcs	10/12/18	10/12/18	0.00	0.00	Packaging2		
150	QC	10 pcs	10/12/18	10/12/18	0.00	0.00	QC5		
160	Packaging	10 pcs	10/12/18	10/12/18	0.00	0.00	Packaging3-2		
170	QC21-SA	10 Ea	10/12/18	10/12/18	0.00	0.00	QC21		

Part Op 105 - Machine blank as per Machinist's turning detail, folio+drawing D4884-1.
Descriptions: 115 - Mill as per folio FB509.
130 - ISSUE P/O: 041513
160 - IDENTIFY AS PER QSI 044 6.1

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M17-4-H900-R1.500	17-4 SS H900 Round Bar 1.500"	3.5000 ft (35 ea)	90-Start up Operation	M129892

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M17-4-H900-R1.500	4	82	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval				
Description Work Order Deviation				Disposition				Completed By			
								Lead hand / Supervisor Approval Verification			
								QC / QA Coordinator Approval			
Root Cause		FAULT CATEGORY									
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐								
Misidentified	☐	Past Due	☐	OTHER :							

DART AEROSPACE LTD		Work Order: 183453
Description: End Fitting, Eye		Part Number: D4884-1
Inspection Dwg: D4884	Rev: A	Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.500	+0.006/-0.001	.501				
1.17	+/-0.030	1.167				
R0.63	+/-0.030	0.63 R5%				
0.500	+/-0.005	.4995				
0.030	+/-0.010	.026				
0.017	+/-0.010	.014				
Ø0.670	+0.000/-0.001	.6695			Micrometer	Variate, but STAR in
30°	+/-0.5°	30°				The tolerance OK
Ø0.125	+0.004/-0.001	.1265				
30°	+/-0.5°	30°				
Ø0.125	+0.004/-0.001	.1265				
Ø1.14	+/-0.030	1.139				
1.132	+/-0.010	1.134	✓		SL10	Vern
Ø0.750	+0.000/-0.001	.7495	✓		SL02	Mic
0.66	+/-0.030	.658	✓		SL10	Vern
2.060	+/-0.005	2.0605	✓		Height Gauge	
R0.25	+/-0.030	.250	✓		Rad gauge	
1.81	+/-0.030	1.809	✓		Height gauge	
3.65	+/-0.030	3.650	✓		SL10	Vern
0.06 x 45°	+/-0.030 x +/-0.5°	.058	✓			
0.947	+/-0.010	.949	✓			
0.059	+/-0.010	.066	✓			
0.063	+/-0.010	.066	✓			
R0.06	+/-0.030	.062	✓			
0.200	+/-0.010	.202	✓			
R0.25	+/-0.030	.250	✓		Rad gauge	
1.39	+/-0.030	1.393	✓		SL10	Vern

Measured by: mmr	Checked by: 92	QC Inspector:
Date: 18/10/11	Date: 18/10/30	Date:

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
A	17.01.31	New Issue	KJ	MA

DARI
AEROSPACE

Container No: S117327



Part: D4884-1

Job No: 183453

Serial No/Batch: S117327

Revision:

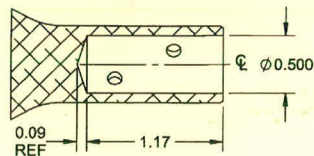
Inspector:

Exp Date:

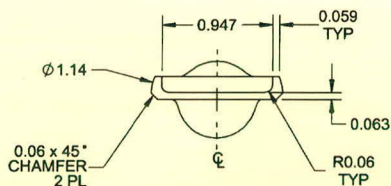
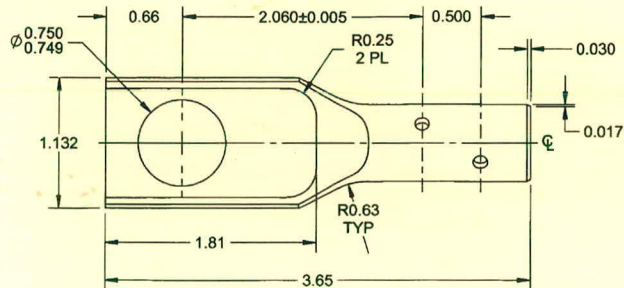
Instructions: Various STC's

1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@derteero.com
www.derteerospace.com

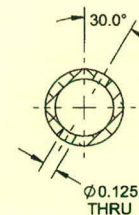
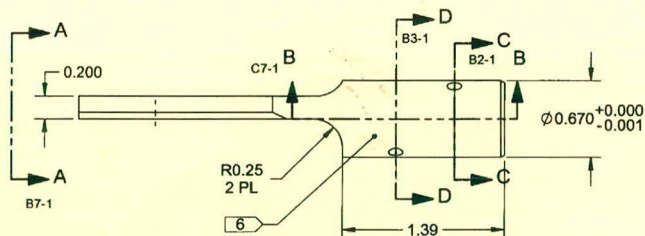
Date: 10/11/18



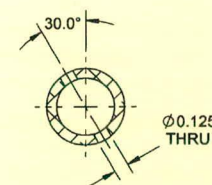
SECTION B-B C5-1



VIEW A-A B6-1



SECTION C-C C4-1



SECTION D-D C5-1

D4884-1 END FITTING, EYE

NOTES:

- 1) MATERIAL: 17-4 PH/S17400/TYPE 630 SS ROUND BAR, H900 CONDITION
PER AMS 5643/ASTM A564
DART SPEC M17-4-R
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.13 lbs
- 8) LIQUID PENETRANT INSPECT PER QSI 038 6.1.1 (ASTM E1417 LEVEL 2)

APPROVED

A		NEW ISSUE		RF		13.09.16	
REV.		DESCRIPTION		BY		DATE	
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4884 TITLE END FITTING COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.					
DRAWN	RF						
CHECKED	DC						
MFG. APPR.	JLM						
APPROVED	HS						
DE APPR.	DS						
DATE	13.12.01	DRAWING NO. D4884		REV. A		SHEET 1 OF 2	
				SCALE		NTS	



Dart Aerospace Ltd.
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Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041513**

Supplier: SKY002-VC
Skyservice
6120 Midfield Road
Mississauga
ON
L5P 1B1 Canada
Phone: 905-678-5636
Fax: 905-678-5841

PO No: PO041513
PO Date: 10/30/18
Due Date: 11/2/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Phone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pynt Terms: Net 30
Freight Terms:
Special Comments:

Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	183453	D4884-1	End Fitting, Eye : Various STC's ISSUE P/O	Firmed	-	11/2/18	4 pcs	0 pcs	4 pcs	\$22.25/pcs	\$89.00
Line Item Note ** rush **											
2	OH184505	4.5NR-OH	Nubbins Receiver Hook	Firmed	-	11/2/18	1 pcs	0 pcs	1 pcs	\$178.00/pcs	\$178.00
Line Item Note **RUSH**											
	OH184504			Firmed	-	11/2/18	1 pcs	0 pcs	1 pcs	\$178.00/pcs	\$178.00
Sub Total:							2	0	2		\$356.00
Grand Total:											\$445.00

DAS
38
9-89



Dart Aerospace Ltd.
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K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO041513

Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 10/30/18 10:09 AM dart.tsimiklis.chrisoula

**skyservice****Work Order Traveler**
Sky Service F.B.O. Inc.

10105 Ryan Avenue, Dorval, Quebec, H9P 1A2

TCCA AMO 53-89 / EASA 145.7142 / BDA AMO 385

WO #: MWO38002	Customer: Dart Aerospace Ltd.	Dept: NDT YUL	Reference: PO041513
Descr:	PN:	S/N:	Qty: 1
Make:	Model:	Reg:	A/C S/N:
TSN:	CSN:	TSO:	
Task: UNSCHEDULED			Sequence: 1

Work Required:

CARRY OUT NDT ON:

4 END FITTINGS , P/N# D4884-1 , J/S# 183453

2 NUBBINS RECEIVER HOOK, P/N# 4.5NR-OH , J/S# OH184504 , OH184505

Action Taken:						Date:	Initial/Stamp:
LPI & MPI C/O IAW ASTM E-1417 AND 1444 REV. 16						OCT 30 2018	
NO CRACK FOUND							
MAGBENCH S/N 208123 CAL DUE: 5-APR-2019							
POWDER 14A BATCH# MPO13600							
CARRIER II BATCH# MPO20165							
PEN ZL-37, MPO13139, CLEANER SKC-S MPO15030, EMU. MPO15896,							
DEV. MPO15030, UV LIGHT M-20142							
Description	Location	P/N	Qty	Batch	S/N Off	S/N On	

DAS
38
9-89

I certified that the maintenance described above has been performed in accordance with the applicable standard of airworthiness.

Signature:	ACA/SCA Stamp	Date:
Name: RAFIK MELIKIAN		OCT 30 2018

